APP.	E.O. NUMBER	CHG. LET.	CHANGE DESCRIPTION	DATE	BY	APP.
		A	ADDED -80 & -81	6/4/62	HLA	
		B	DET 2: .22 WAS .44 .250 DIA SF WAS .500 ± .0025 DET 1: .250 DIA WAS: .5009 .5001	10/1/65		
		C	ADDED NOTE 3 - DET. 3 & 4 WAS 1 EA REQ'D. PER T.P.S. A4981	4/11/69	HOURT	

PART Nº	BEARING Nº	ENGRG Nº	B ±.005	C ±.005	D +.0000 -.0005	E ±.005	F +.000 -.001	G ±.002
830006-809-00074	269A5050-39	269A1335	.795 DIA	.250	.7390 DIA	.847 DIA	.249 DIA	.030
830006-809-00075	269A5050-40	269A1336	.742 DIA	.250	.6865 DIA	.794 DIA	.311 DIA	.030
830006-809-00079	269A5050-43	269A6259	.714 DIA	.250	.6550 DIA	.766 DIA	.249 DIA	.030
830006-809-00080	BLFR-5-045	369-7608	.964 DIA	.250	.9050 DIA.	1.016 DIA.	.311 DIA.	.030
830006-809-00081	BLFR-4-060	369-3111	.683 DIA.	.250	.6240 DIA.	.735 DIA.	.249 DIA.	.030
830006-809-00082	YD-112A	385-6113	1.882	.250	1.8490	1.949	.624 DIA	.045

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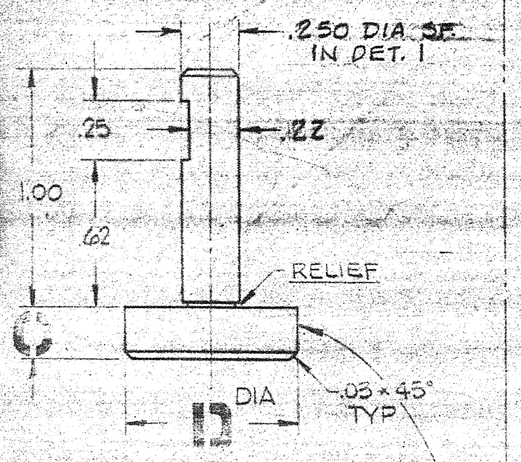
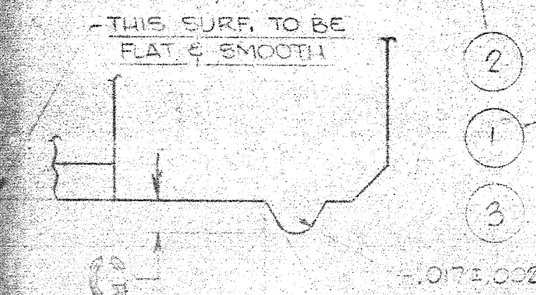
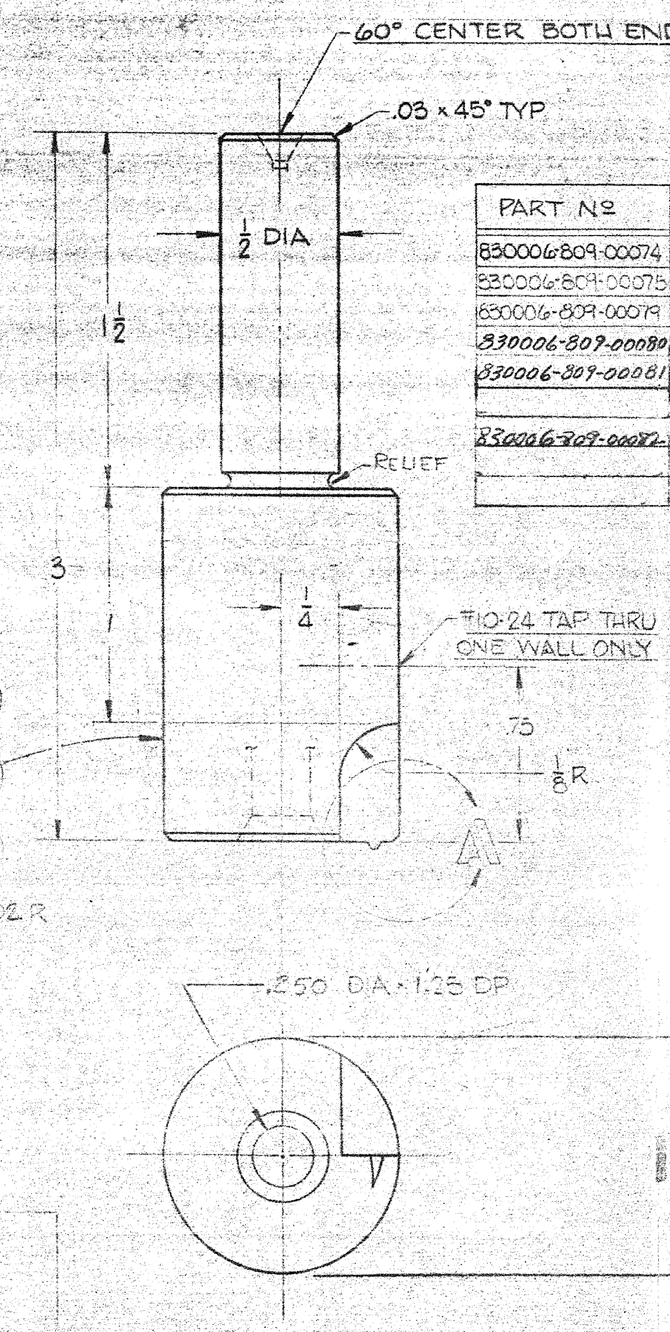
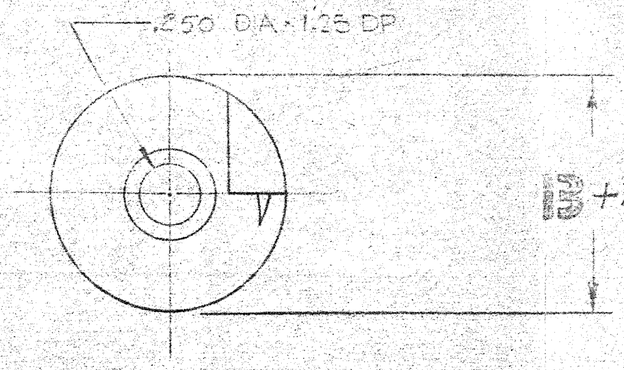
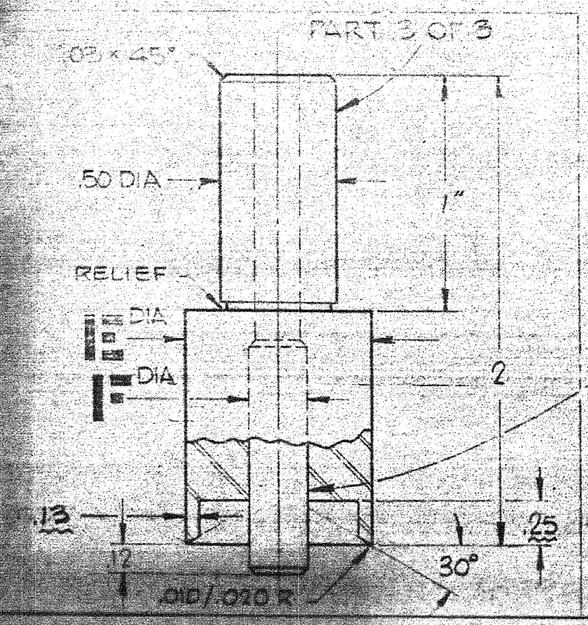


PART 2 OF 3









NOTES:

1. HARDEN TO R/C 55-60 & GRIND (PTS 1, 2, & 3 OF 3)
2. GRIND TO CUT 2014-T6 ALUM FORGING (PT 1 OF 3)
3. PART 3 OF 3 TWO REQ'D. TO BE USED IN TANDEM UPPER & LOWER IDENTICAL, EXCEPT OMIT DET. 4 PILOT PIN ON LOWER

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BREAK ALL SHARP EDGES AND CORNERS UNLESS OTHERWISE SPECIFIED
STAMP OR ETCH TOOL & ENGINEERING PART NOS. ON TOOL

830006-809-00074 C
TOOL NUMBER TABULATED
SHEET ___ OF ___

	4	2	STEEL	DIA x	OHTS
	3	3	STEEL	DIA x	OHTS
	2	1	STEEL	DIA x	OHTS
	1	1		DIA x	OHTS
CODE	DET.	NO. REQ'D	MATERIAL SIZE AND DESCRIPTION		ZONE

HUGHES TOOL COMPANY-AIRCRAFT DIVISION
TOOL DESIGN
DEPT. 63

TITLE: STAKING SET
BEARING ~ PRESS STAKED
ENG. CHANGE

DRAWN	BENEFIEL	2-2-61	TOLERANCES UNLESS OTHERWISE SPECIFIED
CHECKED	Olson	3-7-61	FRACTIONAL X ± 1/16
APPROVED	[illegible]	3-7-61	DECIMAL .XX ± .015
SHEET NO. 1 OF 1	SCALE DOUBLE & NOTED		DECIMAL .XXX ± .005 ANGULAR ± 0° 15'
ENGINEERING PART REF. NO. NOTED			TOOL DRAWING NUMBER 830006-809-00074